



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1513
Job Sheet 181426



Part No: 647.1513

Job Qty: 40 ea

Part Name: Upper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev.A New issue JFS 16/03/09 Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		K1 2018-10-12
100	Bandsaw	40 pcs	9/10/18	9/10/18	0.00	0.10	Bandsaw1		K1 2018-10-12
110	CNC Vertical Machining	40 pcs	9/10/18	9/10/18	0.50	38.10	HAAS1-1		K1 2018-10-12
120	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		K1 2018-10-12
130	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		K1 2018-10-12
140	Outsource	40 pcs	9/10/18	9/10/18			ATG001-VC	5	A.E 18-10-17
150	Packaging	40 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		NOV 05 2018
155	QC	40 pcs	9/10/18	9/10/18	0.00	0.00	QC6		NOV 06 2018
180	Packaging	40 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		NOV 07 2018
190	QC21-SA	40 Ea	9/10/18	9/10/18	0.00	0.00	QC21		NOV 07 2018

Part Op 100 - Cut Blank at 19.500"

Descriptions: 110 - 1-Machine per folio FB465

140 - Issue P/O to ATG : 041369 Hard Anodize Color Black / Prime as per Dwg 647.1500 Rev. D

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S0.375X6.000	7075-T6S Sheet .375" Thick Plate X 6" Wide	32.5200 ft (.813 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S0.375X6.000	33	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Upper Deflector	0.130inches $\pm$ 0.010	0.140 0.120		
2	Upper Deflector	45.000degrees $\pm$ 0.500	45.500 44.500	Angle	
3	Upper Deflector	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter	
4	Upper Deflector	0.318inches $\pm$ 0.005	0.323		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

			0.313	
5	Upper Deflector	23.000degrees $\pm$ 0.500	23.500 22.500	Angle
6	Upper Deflector	4.220inches $\pm$ 0.002	4.222 4.218	
7	Upper Deflector	2.110inches $\pm$ 0.002	2.112 2.108	
8	Upper Deflector	10.180inches $\pm$ 0.010	10.190 10.170	
9	Upper Deflector	0.188inches + 0.005 - 0.001	0.193 0.187	Diameter
10	Upper Deflector	4.000inches $\pm$ 0.010	4.010 3.990	
11	Upper Deflector	0.700inches $\pm$ 0.010	0.710 0.690	
12	Upper Deflector	0.310inches $\pm$ 0.010	0.320 0.300	
13	Upper Deflector	60.000degrees $\pm$ 0.500	60.500 59.500	Angle
14	Upper Deflector	10.890inches $\pm$ 0.010	10.900 10.880	
15	Upper Deflector	6.340inches $\pm$ 0.010	6.350 6.330	
16	Upper Deflector	0.921inches $\pm$ 0.005	0.926 0.916	
17	Upper Deflector	0.340inches + 0.000 - 0.002	0.340 0.338	
18	Upper Deflector	0.040inches $\pm$ 0.010	0.050 0.030	
19	Upper Deflector	45.000degrees $\pm$ 0.500	45.500 44.500	Angle
20	Upper Deflector	0.380inches $\pm$ 0.010	0.390 0.370	
21	Upper Deflector	10.950inches $\pm$ 0.010	10.960 10.940	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Container No: S118028



Part: 647.1513

Job No: 181426

Serial No/Batch: S118028

Revision:

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/12/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041369**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041369

PO Date: 10/17/18

Due Date: 10/31/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Hemmerich, Steven
Phone: 613-632-5200 Ext: 281
shemmerich@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	183547	RBE350A94-5201-20	Cartridge, Dummy, Fuel -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	10/31/18	20 pcs	0 pcs	20 pcs	\$17.00/pcs	\$340.00
							20 x OCT 26 2018				
4	181426	647.1513	Upper Deflector Issue P/O to ATG : Hard Anodize Color Black / Prime as per Dwg 647.1500 Rev. D	Firmed	-	10/31/18	24 pcs	0 pcs	24 pcs	\$12.45/pcs	\$298.80
							24 x NOV 05 2018				
5	184814-A	RBA9930	Rigging Plate, Mixer -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	10/31/18	3 pcs	0 pcs	3 pcs	\$1.00/pcs	\$3.00
							3 x OCT 31 2018				
6	181414	647.1818	Nose Door Spacer ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	10/31/18	50 pcs	0 pcs	50 pcs	\$1.00/pcs	\$50.00
							50 x NOV 05 2018				



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Canada

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PURCHASE ORDER **PO041369**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	178576	RBT400213-5	Top Tab -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	10/31/18	16 pcs	0 pcs	16 pcs	\$1.00/pcs	\$16.00
Grand Total:											\$707.80

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916414

Date: 02-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Christina Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 24 ea	Part: 647.1513 ✓ Upper deflector Job: 23944	Rev: D PO: PO041369 ✓	Line: 4
✓ 50 ea	Part: 647.1818 ✓ Nose Door Spacer Hard Anodize per MIL-A-8625F, Type III, Class 2, Black, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23946	Rev: A PO: PO041369 ✓	Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>2/11/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

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Made in Canada.

